

Date: Wednesday, 7/4/2007 2:44:57 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT CAP
Job Number	: 33288		
Estimate Number	: 10312		
P.O. Number	: N/A	Part Number	: D2646 <i>up</i>
This Issue	: 7/4/2007 S.O. No. : N/A	Drawing Number	: D2646 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: C
Previous Run	: 32427	Material	: N/A
Written By	: <i>[Signature]</i>	Due Date	: 7/17/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	20 Um: Each
Comment	Est: 05.08.22 Hole size revised in Step 5 KJ/JLM Est Rev:H Changed Inserts 07-02-19 JLM est rev I changed inserts 07.06.11 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: *4101*
1-Spin as per Dwg D2646
2-Material release note required

CD 07/07/04
(20)

2.0	D2646P	Aft Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
AFT CAP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Receive & Inspect for Transit Damage
Ensure Material Release Note is attached

C 7/7/18
(20)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK
Inspect dimensions as per Dwg D2646

En 07/07/19
(20)
caenkd

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill using DT8026 as per Dwg D2646.
2-Open holes to .297 as per Dwg D2646.

ml 07/07/24
R2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: AFT CAP

Job Number: 33288

Part Number: D2646

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Debur

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

mul 07/07/30

En 07/07/80 (420)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

N/A

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

ALS71032130

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

INSERT

Batch: _____

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install inserts as per Dwg D2646

N/A

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

stock unpacked
6/7/8/01 (20)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 01/08/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 7/4/2007 2:44:57 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 33288

Part Number: D2646

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(2d)

Comment: FINAL INSPECTION/W/O RELEASE

D 07/08/01

Job Completion



JM 07-08-01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

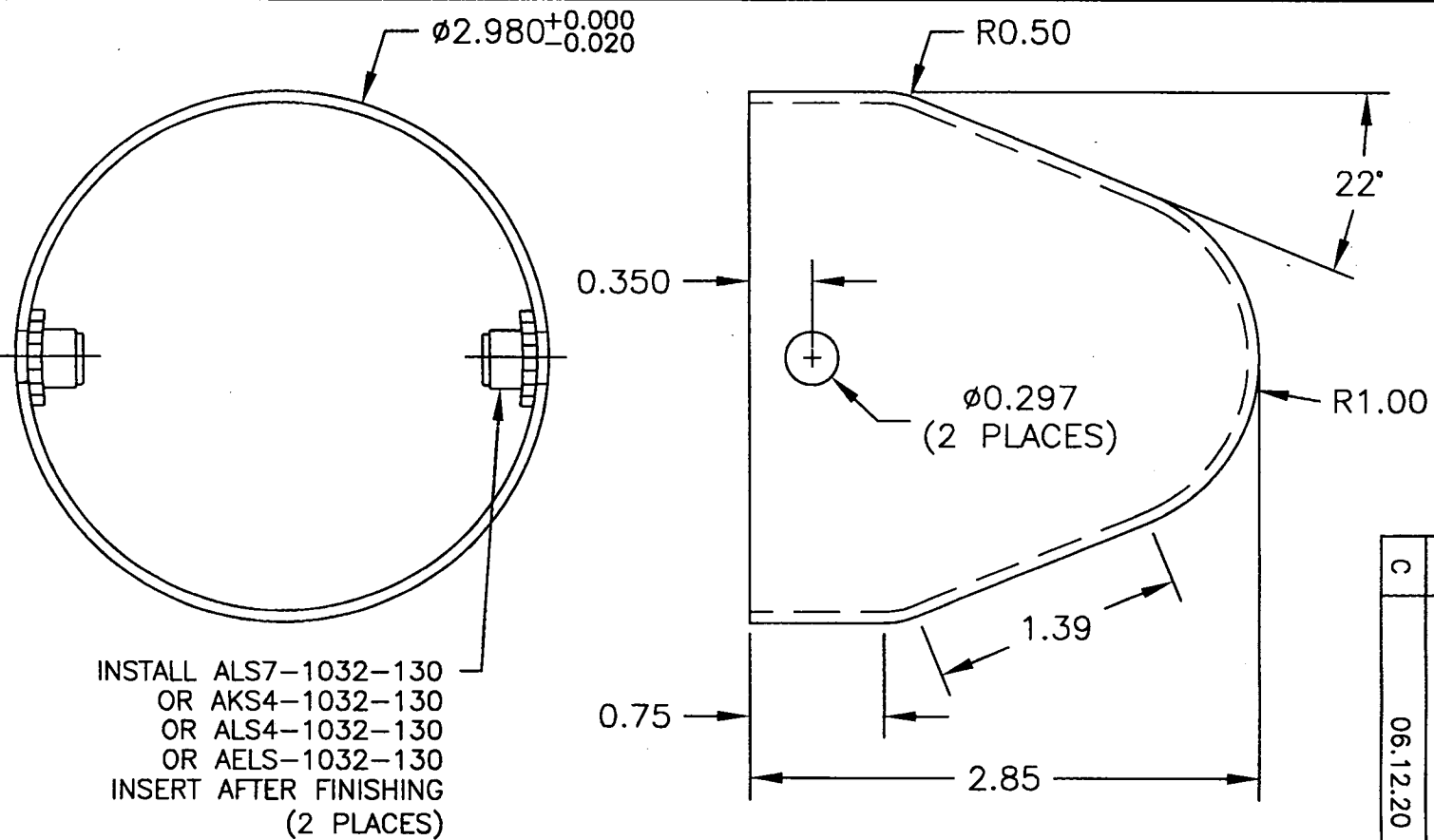
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DS	DRAWN BY	DART AEROSPACE USA, INC.	PORT HADLOCK, WA	REV. C
CHECKED	<i>[Signature]</i>	APPROVED	DRAWING NO.	D2646	SHEET 1 OF 1
DATE	06.12.20		TITLE	AFT CAP	SCALE
					1:1
A		97.03.25	NEW ISSUE		
B		05.04.01	CHANGE TO CLOSED INSERTS		
C		06.12.20	CHANGE TO OPEN ENDED INSERTS		



D2646 AFT CAP

- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
07.02.12

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33288



Sieg's Manufacturing Ltd.

Metal Spinning and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7
TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

INSPECTION REPORT

Date: July 17
Customer: Dart Aerospace
Packing Slip: 31391

Part#:	Quantity	Material	Check holes	Debur edges	Insp. By
D2646 Rev C	50	.0631100	N/A	✓	AK

Notes:

Material Certification Attached: Yes



Alcoa Mill Products

1480 Mannheim Pike
Lancaster Pa 17601

Certification of Test Results

SOLD TO	COPPER & BRASS SALES INC 22315 WEST ELEVEN MILE ROAD SOUTHFIELD, MI 48034	SHIP TO	COPPER & BRASS SALES INC 6555 E. DAVIDSON DETROIT, MI 48212	CERT NO 0000630431
				DATE 2/12/2005
				SKID NO 350025
				SKID WGT 6,654
				PAGE 1 OF 1

ORDER NO	LS8335	PO NO	CB2548			MILL FINISH
ITEM NO	1	PART NO	050393-8			NON ANODIZE QUALITY
ALLOY	1100	TEMPER	O	FORM	COIL	OUT: STANDARD MILL FINISH
GAUGE	.06300	WIDTH	48.0000	LENGTH	0.0000	IN: STANDARD MILL FINISH
						NOT EMBOSSED

LOT: 245473 COIL: A01 DROP: 04M0509

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
*U504111	0.14	0.52	0.13	0.01	0.01	0.01	0.01	0.01	0.01

HEAD ULTIMATE STRENGTH 13.2 KSI
TAIL ULTIMATE STRENGTH 13.5 KSI
HEAD YIELD STRENGTH (OFFSET = .2%) 5.2 KSI
TAIL YIELD STRENGTH (OFFSET = .2%) 5.1 KSI
HEAD ELONGATION (G.L. = 2 IN) 33.5 %
TAIL ELONGATION (G.L. = 2 IN) 32 %

* AS REPORTED BY SUPPLIER
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-02a

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:
ASME SB209 1100 O, AMS 4001H 1100 O,
ASTM B209-04 1100 O, AMS-QQ-A-250/1 1100 O

CERTIFICATION OF TEST RESULTS SHALL NOT BE REPRODUCED EXCEPT IN FULL
** END OF CERTIFICATION **

Attn: Qa Dept

Date	9-10-05
Cust.	Siegl
W/O #	139277
Qty.	2036 Pcs.
<input checked="" type="checkbox"/> Size	<input checked="" type="checkbox"/> Special Instructions
<input type="checkbox"/> Part #	<input checked="" type="checkbox"/> Alloy <input type="checkbox"/> Heat/Lot
These test reports are for material shipped on your PO # 21000	
From Copper & Brass Sales	
Shane Durbin	
Quality Representative	
Customer Part #	

This document certifies the material above has been tested in accordance with applicable specifications described herein and has met those requirements. The material is subject to terms and conditions on the Alcoa sales order agreement.

Authorized By: JEFF KREADY, LAB SUPERVISOR

